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647.0112

Job Sheet 204981



Part No: 647.0112

Job Qty: 150 pcs

Part Name: Strut Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/23/19

Job Tracking No:

Due Date: 2/14/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 647.0100 REV.B SHEET 3 IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS IPP REV:B 18.02.08 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	150 pcs		2/14/20	0.17	5.00	Waterjet - Flow		TF Feb 25, 2020
110	QC 2	150 pcs		2/14/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		TF Feb 25, 2020
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120	QC 8	150 pcs	2/14/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
130	Small Fab - Brake NC - B4B	150 pcs	2/14/20	0.25 7.50	Small Fab - Brake - 1 - B4B
					Small Fab - Brake - 2 - B4B
					Small Fab - Brake - 3 - B4B
140	QC 5	150 pcs	2/14/20	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
150	Spray Paint - 2 - B4B	150 pcs	2/14/20	0.00 3.51	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B

DAS
40

FEB 26 2020

DAS
82
9-89

GP 20-02-28

DAS
FEB 28 2020
40
9-89

RD 20-3-1

160 QC 14	150 pcs	2/14/20	0.00 0.00	Spray Paint - 4 - B4B	
				QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	DAS 40 9-89
				QC 14 - 19	MAR 03 2020
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
170 Packaging 3-1 - Stock - B4B	150 pcs <i>240 pcs mld</i>	2/14/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS 28 9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	150 pcs	2/14/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	DAS 21 9-89
Part Op 100 - 1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary					
Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)					
120 - (QC8- Inspect parts - second check)					

130 - (Form as per dwg) USE DT9834 FOR FORMING

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Spray Paint / NDT Room) PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N PRIME AS PER DWG NOTE 6
BATCH: S 296137

160 - (QC14- Inspect Spray Paint)

170 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	4.8750 sf (.0325 ea)	100-Waterjet - Flow - 1	<u>S243466</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S14GA	5	79	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut Bracket	0.177Inches + 0.005 - 0.001	0.182 0.176	0.177	✓
2	Strut Bracket	0.191Inches + 0.005 - 0.001	0.196 0.190	0.192	✓
3	Strut Bracket	0.300Inches ± 0.030	0.330 0.270	0.300	✓
4	Strut Bracket	0.900Inches ± 0.030	0.930 0.870	0.898	✓
5	Strut Bracket	0.350Inches ± 0.010	0.360 0.340	0.351	✓
6	Strut Bracket	1.500Inches ± 0.030	1.530 1.470	1.507	✓
7	Strut Bracket	1.006Inches ± 0.030	1.036 0.976	1.006	✓
8	Strut Bracket	0.080Inches ± 0.010	0.090 0.070	0.076	✓

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS				
Job: _____	Rework ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐		
Part No. _____	Scrap ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐		
	Use-as-is ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐		
				Quality ☐		
Date: _____		Sequence #: _____		MRB (QS1042)		
Description Work Order Deviation		Disposition				
		Completed By				
		Lead hand / Supervisor				
		QC / QA Coordinator				
Root Cause		FAULT CATEGORY				
Operator ☐		Contamination ☐		Power Loss/Surge ☐		Positioned Wrong ☐
Manufacturing Process ☐		Misaligned/off center ☐		Folio/Program ☐		Outside Tolerance ☐
Equip/Tooling ☐		BOM/Route ☐		Grain Direction ☐		Drawing ☐
Handling/Preservation ☐		Broken/Damage/Defect ☐		Weld ☐		Finish ☐
Material ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐
Product Improvement ☐		Drill Holes ☐		Out of Sequence ☐		Misread ☐
Process Improvement ☐		Fit/Function ☐		Off-set/Set-up ☐		
Human Factors ☐		Other/Details: _____				